

Work Order ID 61522

August 30, 2010 10:10:37 AM

Page 1

Item ID: D2858-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Hinge Bracket

Start Date: 30/08/2010 Start Qty: 6.00

Cust Item ID:

Required Date: 08/09/2010 Req'd Qty: 6.00

Customer:

Reference:

10-08-30

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2858	Rev B								

100

0.00



Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut blanks 5.850

" Note: 1 Blank Makes 3 Parts

0.00

B.A 10/09/13

6

φ

110

0.00



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1-Machine per folio FA941

FOLIO REV: *B*

DWG REV: *B*

2-Deburr any rough edges

0.00

B.A 10/09/13

6

φ

120

0.00



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

B.A 10/09/13

6

φ

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Required Date: 08/09/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		BP 10/09/14		6	Ø		
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00		BR 10-9-14		6			
150 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M 115291 Memo START TIME: 2:00 3:20 FINISH TIME: 2:30	0.00 0.00		BR 10-9-21		6			

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Item ID: D2858-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Hinge Bracket

Start Date: 30/08/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 08/09/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		7/11 10/09/22		6	0		
170 Packaging Packaging	Identify as per dwg & Stock Location: 25 Memo	0.00 0.00							10/9/23
180 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							10/09/23

MF
10-9-22

Picklist Print

August 30, 2010 10:10:36 AM

Page 1

Work Order ID: 61522



Parent Item: D2858-1



Parent Item Name: Hinge Bracket

Start Date: 30/08/2010

Required Date: 08/09/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP ☐ C ☐ 00.06.22 ☐ Removed P/O for powder coat ☐ EC ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.500X01.25 0		Purchased	No			100	f	41.1080	0.163	1.029474			



6061-T6 Bar 1.50 x 1.25

Location

Loc Qty

Loc Code

MAT10

41.10795

107461

11.26315

110936

29.8448

1.0294 ^{ft} H.A 10/09/13

DART AEROSPACE LTD		Work Order:	61522
Description: Hinge Bracket		Part Number:	D2858-1
Inspection Dwg: D2858 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.171	+0.005/-0.001	Ø0.173	✓		Vern	GA-01
Ø0.400	+0.006/-0.001	Ø0.404	✓		"	"
R0.125	+/-0.010	R0.125	✓		Rad gage	ref
0.328	+/-0.010	0.330	✓		Vern	GA-01
0.820	+/-0.005	0.820	✓		"	"
1.476	+/-0.010	1.480	✓		"	"
0.342	+/-0.010	0.344	✓		"	"
0.875	+/-0.005	0.875	✓		"	"
1.56	+/-0.030	1.564	✓		"	"
0.147	+/-0.010	0.145	✓		"	"
0.717	+/-0.010	0.718	✓		H-6	31006
0.697	+/-0.010	0.699	✓		Vern	GA-01
0.229	+/-0.010	0.230	✓		"	"
R0.125	+/-0.010	R0.125	✓		Rad gage	ref.
R0.063	+/-0.010	R0.063	✓		"	"
0.063	+/-0.010	0.064	✓		Mic	GA-03
0.126	+/-0.010	0.125	✓		Vern	GA-01
0.630	+/-0.010	0.630	✓		H-6	31006
R0.354	+/-0.010	R0.354	✓		Rad Gage	ref.
0.965	+/-0.010	0.968	✓		Vern	GA-01
Ø0.166	+0.005/-0.001	Ø0.168	✓		"	"
R0.125	+/-0.010	R0.125	✓		Rad Gage	ref.
32.7°	+/-0.5°	32.7°	✓		Protractor	MLL - BR

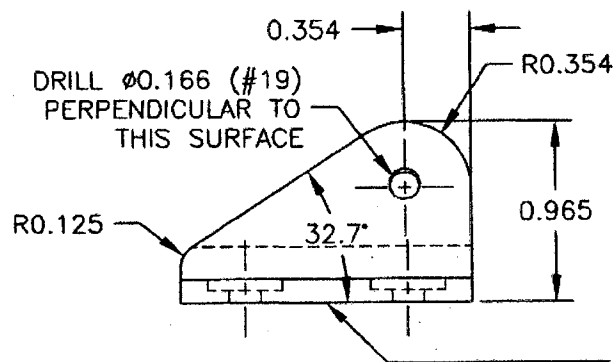
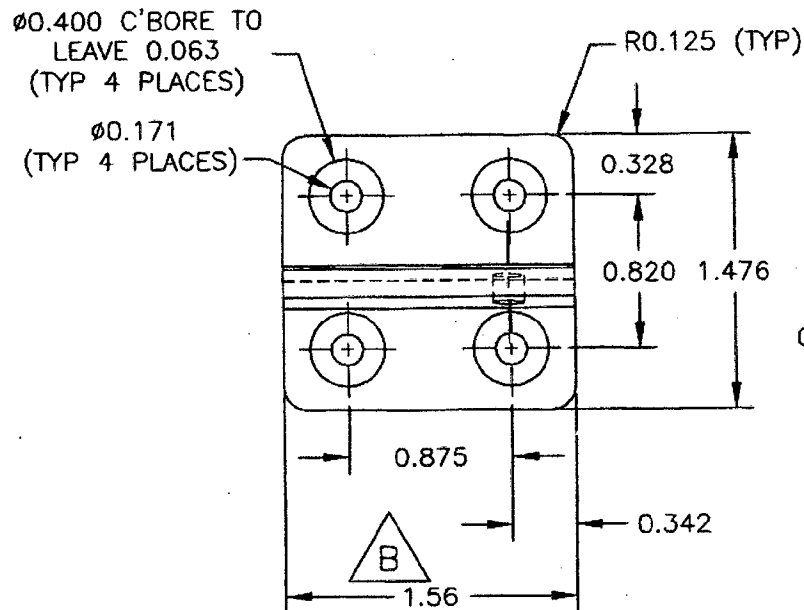
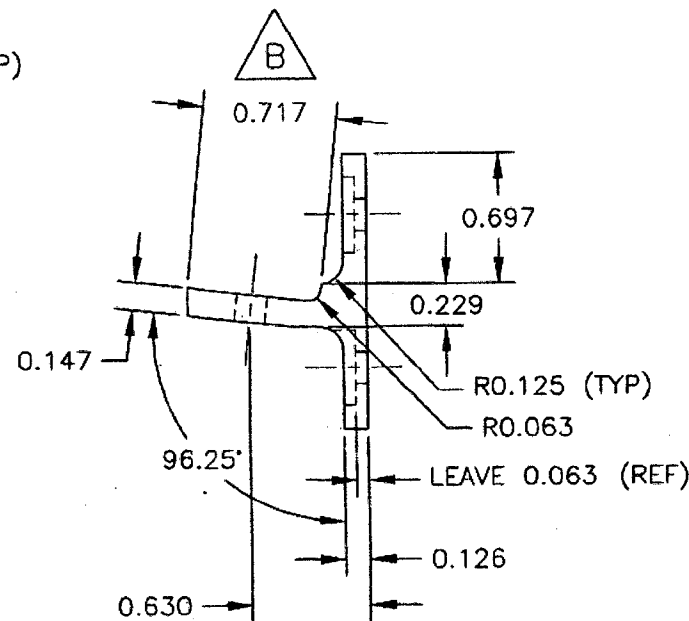
Measured by:	H.A	Audited by:	BB	Prototype Approval:	N/A
Date:	10/09/13	Date:	10/09/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.30	New Issue	KJ/EC/DD	DA



RELEASED
99.03.03 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD
VE	VE	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
UP	VE	D2858
DATE	TITLE	REV. B
99.02.28	HINGE BRACKET	SHEET 1 OF 1
A	NEW ISSUE	SCALE
B	0.717 WAS 0.667, 1.56 WAS 1.559	1:1



ENGRAVE P/N CENTERED ON
BASE 0.003 DEEP (0.010 MAX)

D2858-1 SHOWN
D2858-2 OPPOSITE

MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) OR (QQ-A-200/8) OR (QQ-A-225/8)
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

w/o 61522